

Date: 6/23/2006 8:53AM  
User: Linda Lacelle

# PROCESS SHEET

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job No.	: 27674	Part No.	: D3391021
Estimate No.	: 10467	Drawing No.	: D3391 REV E
P.O. No.	: <u>N/A</u> SO No.	Drawing Rev.	: E
First Issue	: <u>N/A</u>	Project No.	: N/A
Prsht Rev.	: NC Type : MACHINED PARTS	Material	: <u>N/A</u>
This Issue	: 6/23/2006	Due Date	: 7/15/2006 QTY: 1
Prev. Run	: 27673		

Written by:

Checked & Approved by:

Comment :

Est. A 05.09.13 New issue KJ/JLM  
Est. B 06.02.10 Dwg rev.D ecn 773 EC  
Est. C 06.05.02 Added inspections EC

Job Number:



Seq. No.	Machine or Operation	Description
1.0	D6013047	SKIDTUBE MAT'L
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) SKIDTUBE MAT'L Pick: Qty Part Number Description Batch 1 D6013-047 Extrusion <u>B23935 DP06-6-23</u>	
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1 Cut extrusion to 46.52 +0.010 -0.020 <u>ml 06/06/23</u>	
3.0	BENDING	BENDING MACHINE
	Comment: Nc bender Bend as per Dwg D3391 Using Bend Prog 3391021 <u>DP06-6-23</u>	
4.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP <u>Im 06-06-23 (1)</u>	
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA590 Rev. <u>AA</u> & Dwg D3391 Rev. <u>E</u> Identify as D3391-1 2-Deburr <u>ml 06/07/10</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Job Number:




Seq. No.	Machine or Operation	Description
6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>9nd 06/07/10 1</i>
7.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<i>5.6 06/08/03 1</i>
8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1	
	1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A")	<i>pmr 06-08-280</i> <i>pmr 06-08-30 ①</i>
	2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step	
	3-Open tow cap holes to .208" as per Dwg D3391	
	4-Open Tow Ring hole to .640" as per Dwg D3391	
	5-Drill wearplate holes as per Dwg D3391 Using Dt8217 & DT8878	
	6--Deburr <i>pmr 06-08-30 ①</i>	
9.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	<i>DP 6-8-30</i>
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	<i>m.r 06/10/19 ①</i>
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<i>yl 07/02/26 x-1</i>
12.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	<i>M/103706 ①</i> <i>m.r 07/03/18</i>
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<i>a.n 07/03/18 ①</i>
14.0	NAS1330C3KB166	INSERT

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-03-19	1	TOUCH UP (PAINT)						

**NOTE:** Date & initial all entries

Job Number:



Seq. No.	Machine or Operation	Description
	Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s) Rivnut Pick: Part Number Description Batch Qty NAS1330C3KB166 Insert	M.H. (14) 07/03/16 M100732
15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Install Inserts as per Dwg	M.H. 07/03/16
16.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	M.H. 07-03-16
17.0	D3401041	Tow Cap Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Tow Cap Assembly Pick: Part Number Description Batch Qty D3401-041 Tow Cap	529214
18.0	AN3C4A	BOLT
	Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Bolt Pick: Part Number Description Batch Qty AN3C4A Bolt	M101390
19.0	NAS1515H3L	WASHER
	Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Washer Pick: Part Number Description Batch Qty NAS1515H3L Washer	M103641
20.0	AN960C10L	washer
	Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) washer	M102832
21.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Install tow Cap as per Dwg D3391 Identify as D3391-021	a.m. 07/03/19
22.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP Inspect thread of each insert using DT8821	0703-19

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 18 Date: 07/03/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Job Number:



Seq. No.	Machine or Operation	Description
23.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>PPP B3-91P</i> <i>07/13/20</i>	
24.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21 <i>07/03/20</i> ①	

Job Completion



*U 07-0320*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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